

5
Work Order ID 124300

September-11-14 12:01:34 PM

124300

Page 1

Item ID: D3535-25

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearplate Center

Stop

NS2

Start Date: 9/10/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 14-09-17

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3535	Rev B
-------	-------

100 0.00

DAS

100

FLOW WATER JET

23

Waterjet

9-89

FLOW CNC Waterjet

Memo 0.00

12 0

14-09-28

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

110 0.00

DAS

110

Memo 0.00

23

QC

9-89

Quality Control

14-09-28

120 0.00

DAS

120

Memo 0.00

38

QC

9-89

Quality Control

14-09-29

(13)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. _____	Suspected Unapproved <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	
				Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks <input type="checkbox"/>	Broken/Damage/Dent <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

Work Order ID 124300

September-11-14 12:01:34 PM

124300

Page 2

Item ID: D3535-25

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearplate Center

Stop

NS2

Start Date: 9/10/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE Memo	0.00 0.00		DAS 30 9-89	12				14/09/29
Brake NC	1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326- Form joggle on Punch as per Dwg D3535 using Jig DT8158 identify as D3535-25								
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 38 9-89	13				14-9-30
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M128504. Memo START TIME: 1:35 FINISH TIME: 2:05 OVEN TEMPERATURE: 200	0.00 0.00				13	8	41-10-7.	DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	Skid-tube	Crosstube	Water Jet	Engineering		
NCR No. _____	Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality		
	Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other		
	Suspected Unapproved	Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions	Pressure/Forced
Bending	Bend	Grain	Over/Under tolerance	Set-up
Centre Not Concentric	BOM/Route	Hardware	Part Incorrect	Temperature/Cure
Cracks	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
Crimp/Kink/Ripple/Wave	Burrs	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
Cuffs	Contamination	Misaligned/off center	Positioned Wrong	Power Loss/Surge
Crushing	Countersink	Mislabeled	Other	
Heat Treat	Cut Too Short	Misread		
Inspection Strip in Tube	Drawing	Off-set		
Marks/Chatter	Drill Holes	Out of Calibration		
Turning Sequence	Finish	Out of Sequence		
Wave/Twist in Tube	Fit/Function			

Work Order ID 124300

September-11-14 12:01:34 PM

124300

Page 3

Item ID: D3535-25

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearplate Center

Stop

NS2

Start Date: 9/10/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

DAS

38

9-89

14-10-8

160

QC

Memo

0.00

(13)

Quality Control

170

Identify as per dwg & Stock Location: FP-007

0.00

170

Packaging

Memo

0.00

X/3 d 11/10/09

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

14/10/9 08

Quality Control

W/P
14-10-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				
Bending	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions
Centre Not Concentric	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Pressure/Forced
Cracks	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Set-up
Crimp/Kink/Ripple/Wave	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Temperature/Cure
Cuffs	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Weld
Crushing	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Wrong Stock Pulled
Heat Treat	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Other
Inspection Strip in Tube	Drawing	<input type="checkbox"/>	Misread		
Marks/Chatter	Drill Holes	<input type="checkbox"/>	Off-set		
Turning Sequence	Finish	<input type="checkbox"/>	Out of Calibration		
Wave/Twist in Tube	Fit/Function	<input type="checkbox"/>	Out of Sequence		

Picklist Print

September-11-14 12:01:34 PM

Page 1

Work Order ID: 124300

124300

Parent Item: D3535-25

D3535-25

Parent Item Name: Wearplate Center

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	160.0319	0.51	4.294737	**	7	DAS 23 14-09-28 9.89

M304S20GA

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	160.0318948	
m126852	0.31	
m127454	26.1018948	
m128435	92.94	
m129128	0.5	
m129530	5.2	
m129845	34.98	

130345

130345

DQA: _____ Date: _____



QA Closed: _____ Date: _____

Work Order update only

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
				Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>			
				Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
				Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>			
				Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
				Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
				Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>			
				Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>					
				Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>					
				Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
				Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					

DART AEROSPACE LTD	Work Order:	124300
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

~~DAC~~

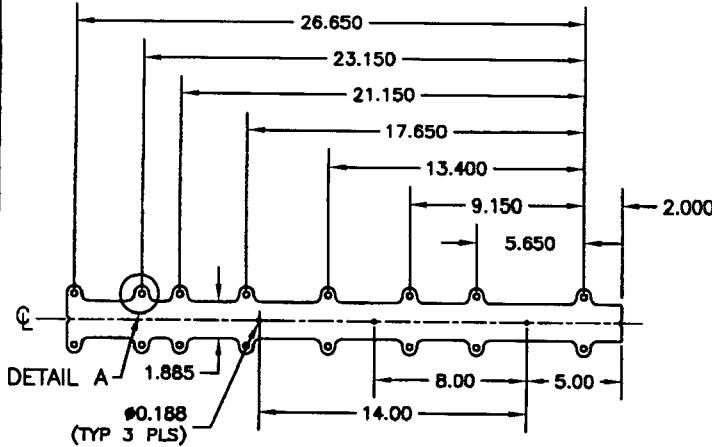
Measured by:	23 8-89
Date:	14-09-28

Audited by:	9-8
Date:	14-9-29

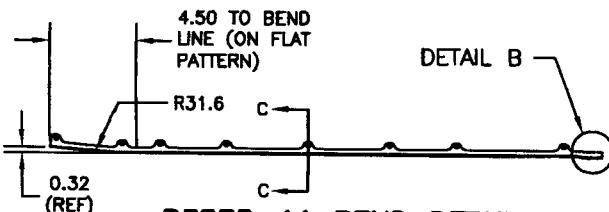
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	JK

DART



D3535-11F FLAT PATTERN



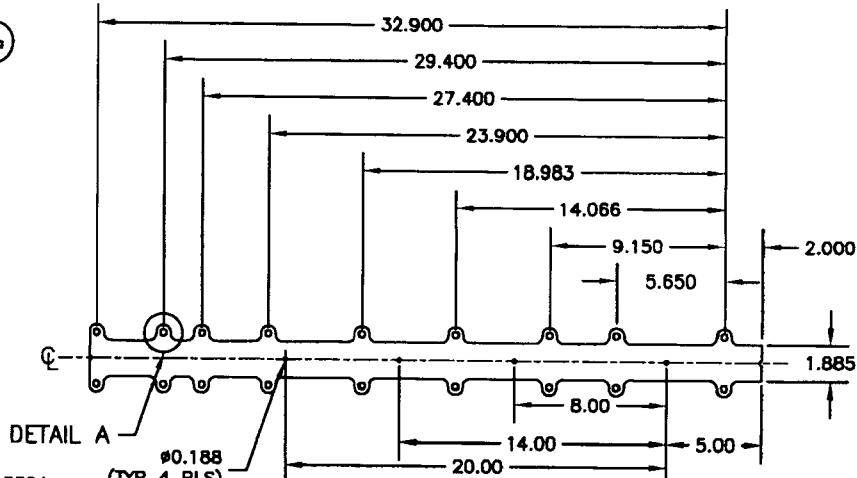
D3535-11 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124300 MUS

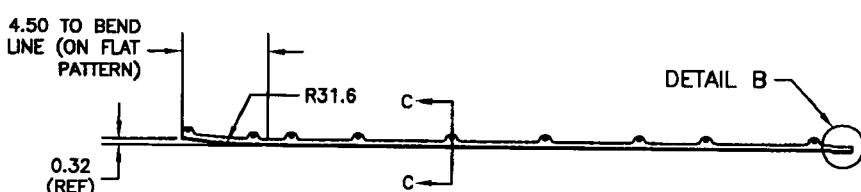
1409-17

RELEASED

57-04-24



D3535-13F FLAT PATTERN

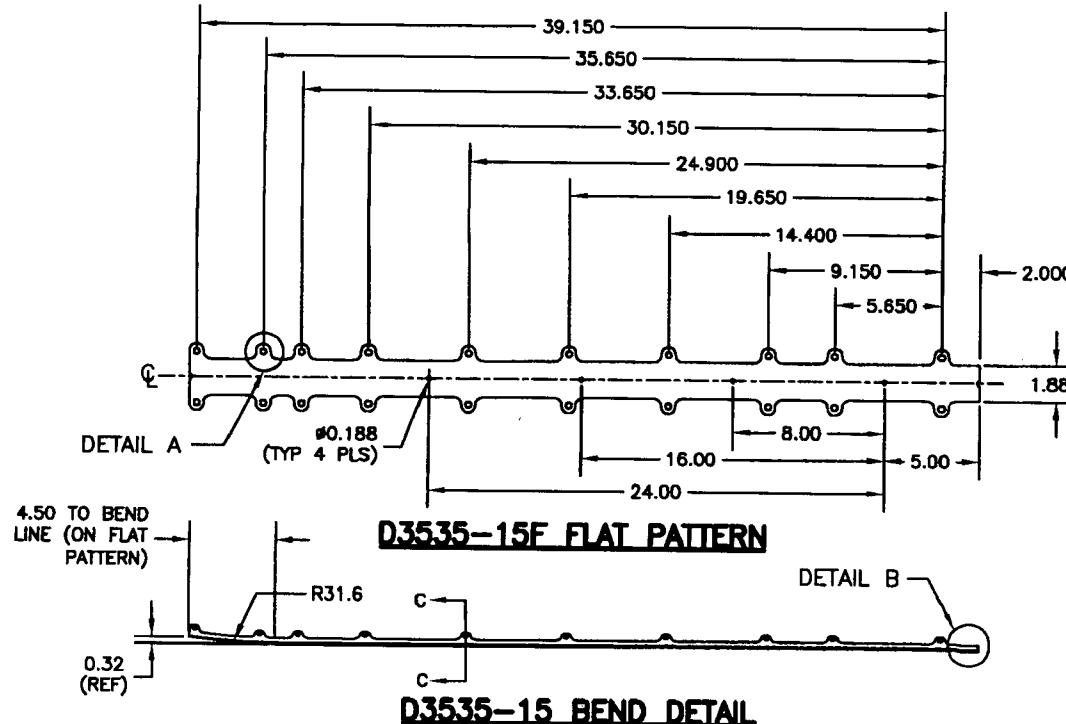


D3535-13 BEND DETAIL

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C8	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D3535
DATE		TITLE
07.04.17		WEARSHOE
A		NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC
		REV. B
		SH. 1 OF 7
		SCALE
		1:10

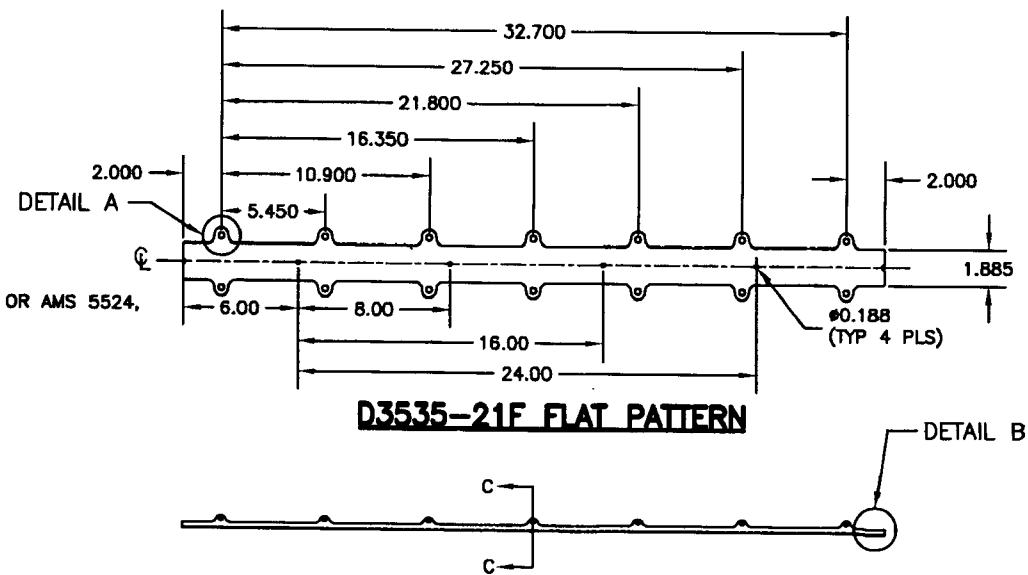
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



四〇三

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524-20 GAUGE (0.038 THICK)
(REF DART SPEC M304520GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \varnothing
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

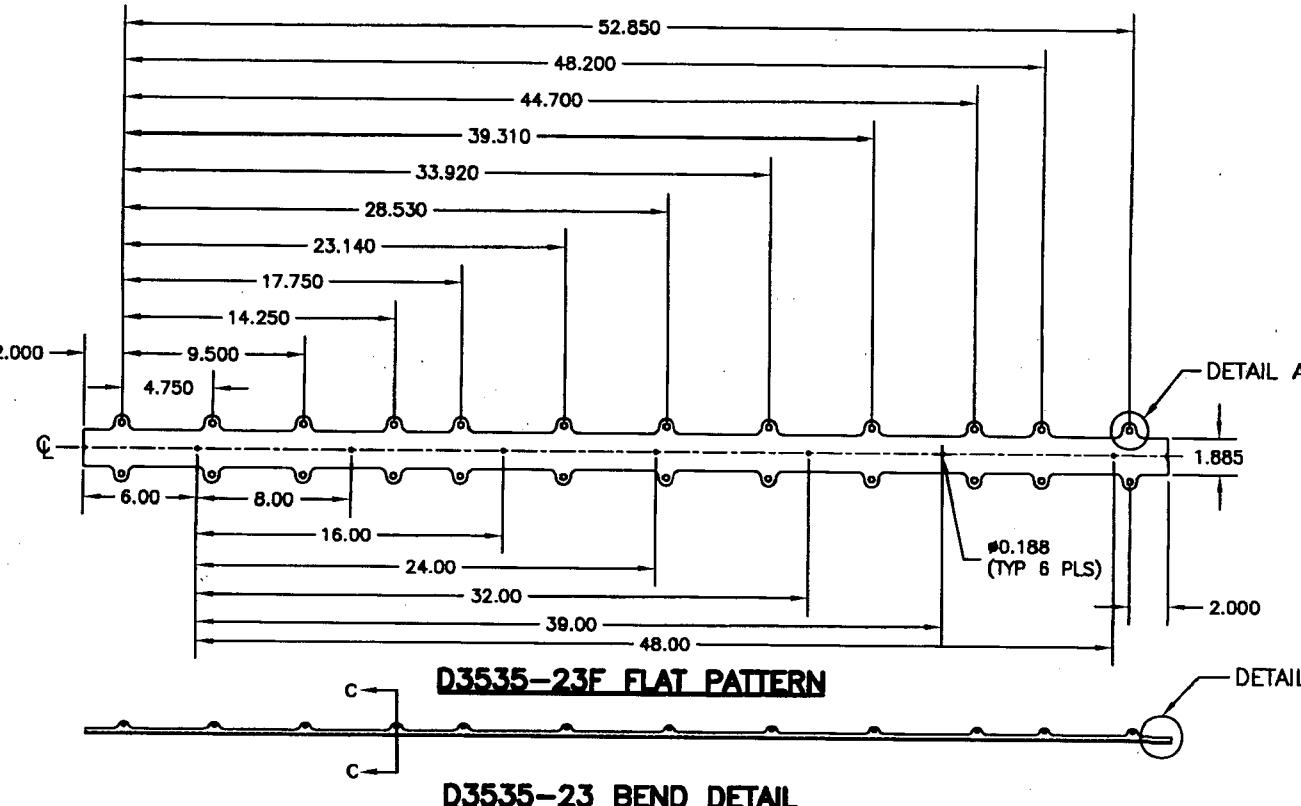


D3535-21 BEND DETAIL

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DESIGN CB		APPROVED PH		PORT HADLOCK, WA	
CHECKED PH	DATE 07.04.17	DRAWING NO. D3535	REV. B		
TITLE WEARSHOE		SHEET 2 OF 7	SCALE 1:10		

NOTES

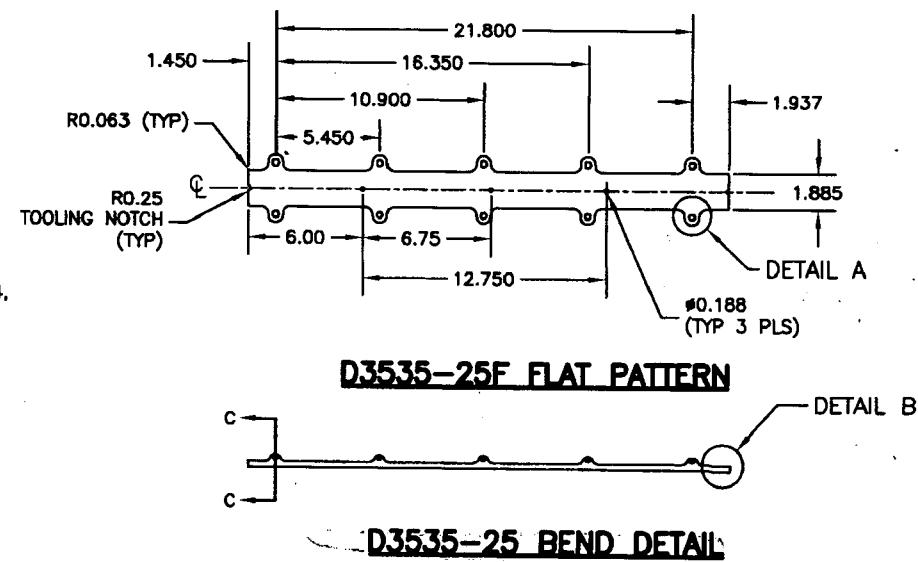
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20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

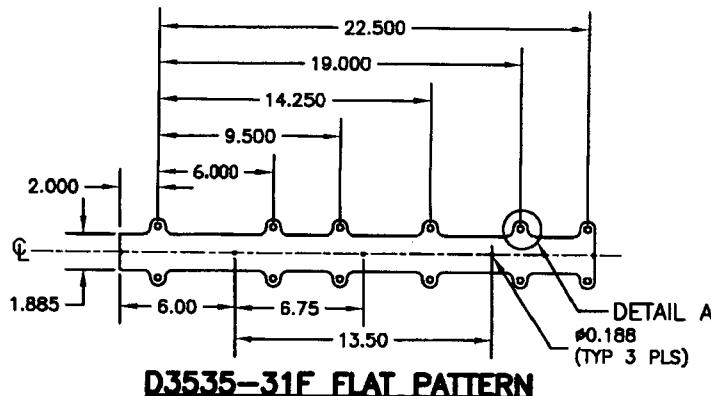


RELEASED
07.04.24

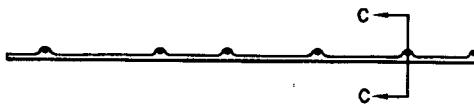
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CHECKED MH	APPROVED MH	DRAWING NO. D3535
DATE 07.04.17		SCALE 1:10

REV. B
SHEET 3 OF 7
TITLE
WEARSHOE

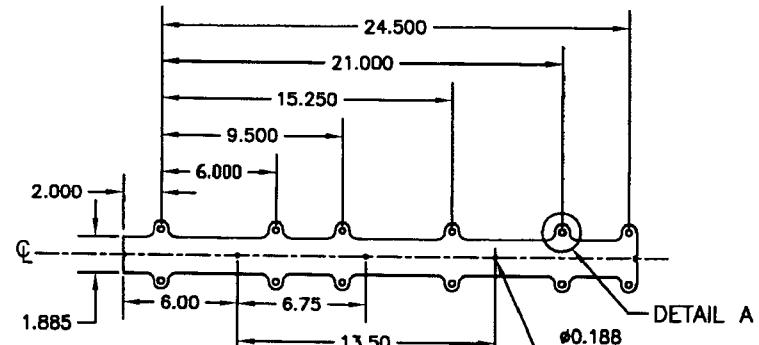




D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



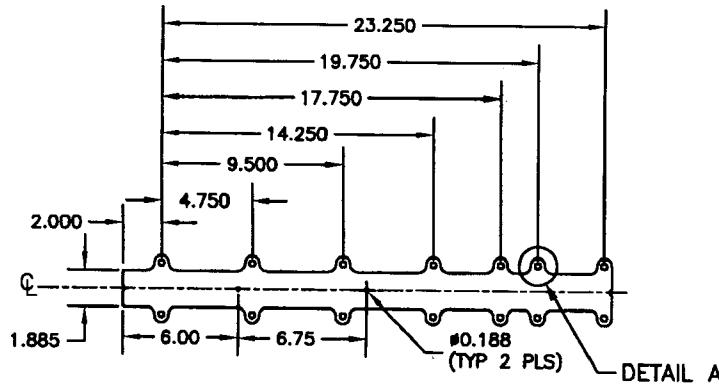
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

REV. B
SHEET 4 OF 7
SCALE
1:10

RELEASED
07.04.17

DART



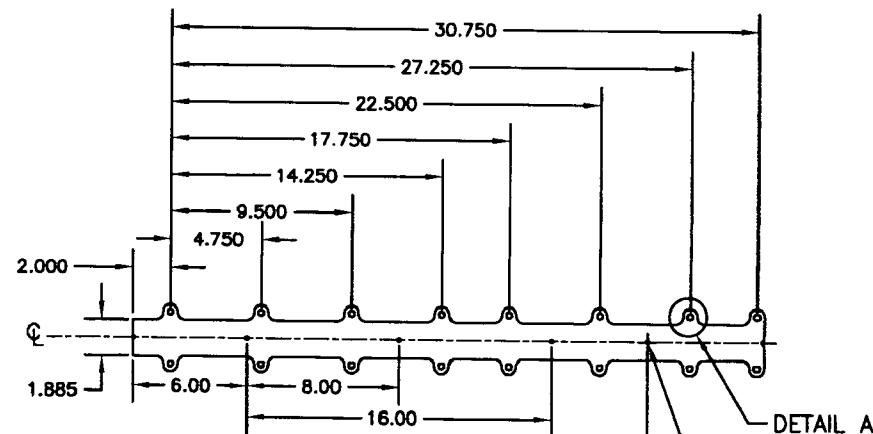
D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-37F FLAT PATTERN

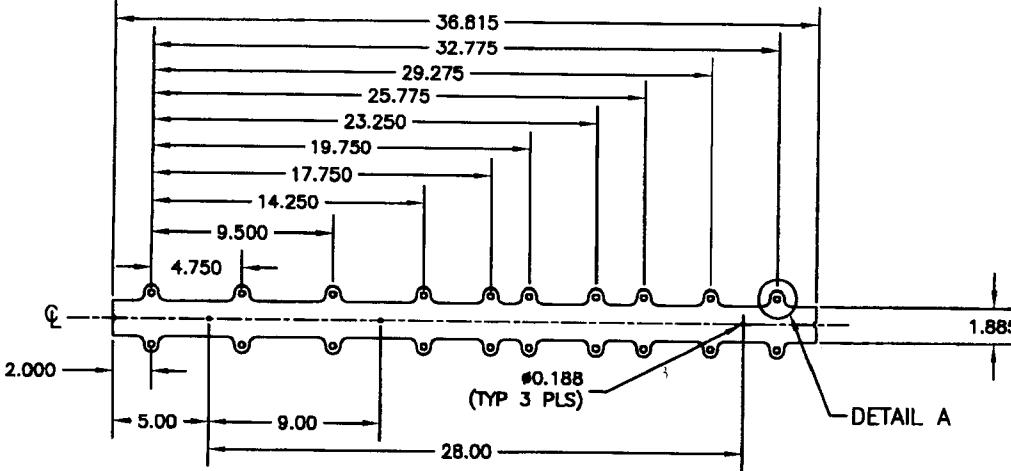


D3535-37 BEND DETAIL

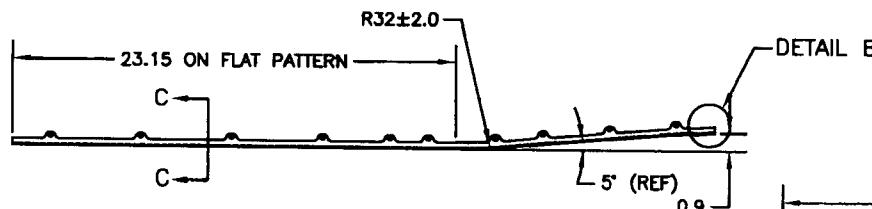
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C.B	P4	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 5 OF 7
		D3535	
DATE		WEARSHOE	1:10
07.04.17			

RELEASED
07.04.24

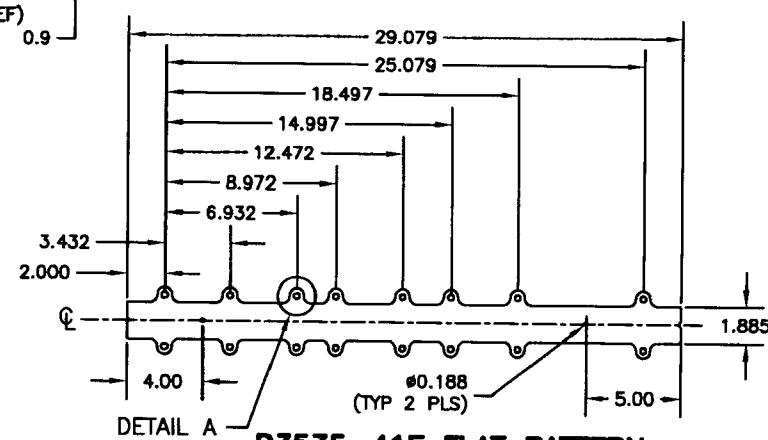
DART



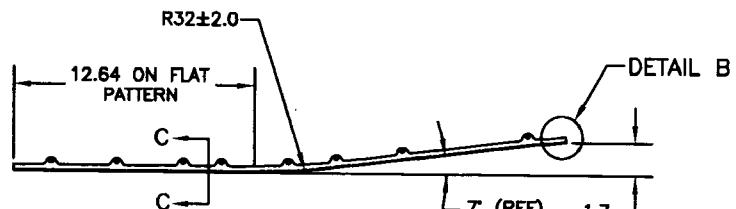
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	DRAWING NO.
		D3535
		DATE
07.04.17		TITLE
		WEARSHOE
		SCALE
		1:10
		REV. B
		SHEET 6 OF 7
		9

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

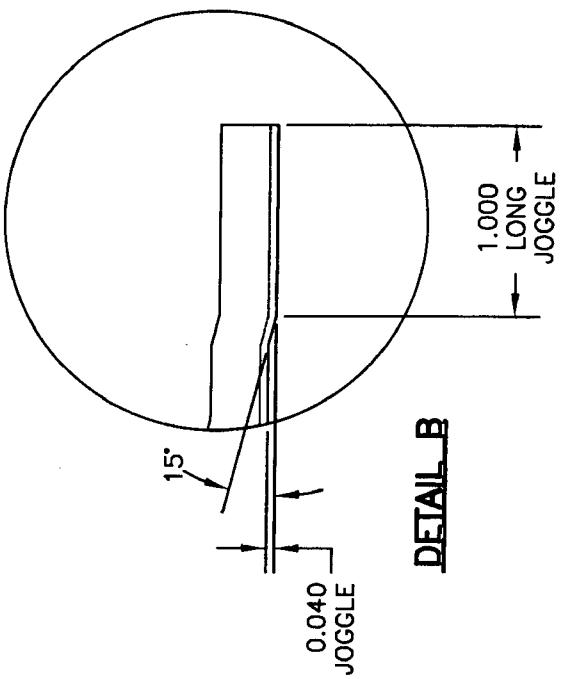
REV. B

SHEET 7 OF 7

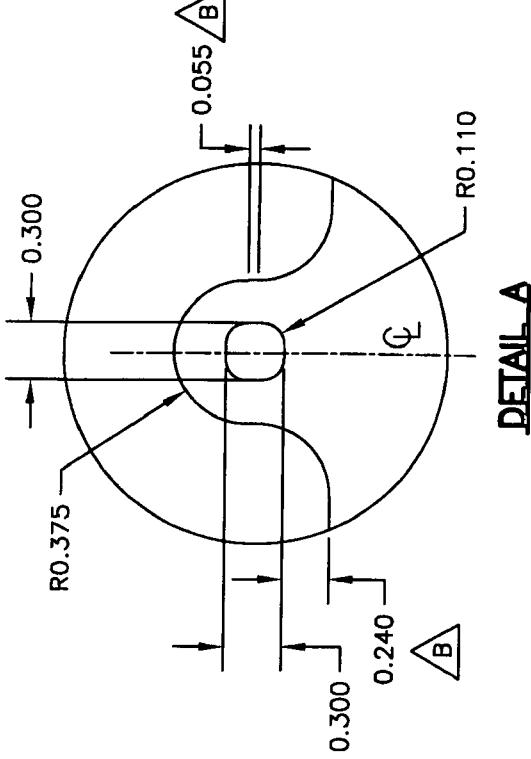
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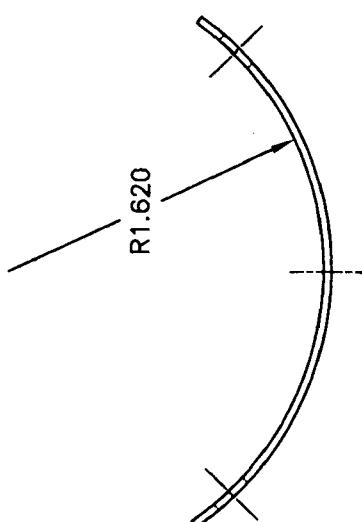
RELEASED

07.04.24 *[Signature]*

DETAIL B



DETAIL A



SECTION C-C

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